

Date: Wednesday, 5/31/2006 7:39:43 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STA 84 BRACKET
Job Number	: 27302		
Estimate Number	: 11035		
P.O. Number	: N/A	Part Number	: D28032
This Issue	: 5/31/2006 S.O. No. : N/A	Drawing Number	: D2803 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 26588	Material	: N/A
Written By	: <i>See Lg Comment Below</i>	Due Date	: 6/18/2006 Qty: 20 Um: Each
Checked & Approved By	: <i>06.03.31 N</i>		
Comment	: Est. A 00.11.06 New Issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X10000	6061-T6 Bar .50" x 10.0"
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Comment: Qty.: 2.0125 f(s)/Unit Total: 40.2507 f(s)

6061-T6 Bar .50" x 10.0"

Material: 6061-T6 bar 10.00" x 0.50"

Batch: M100285

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks per template DT8533

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA102

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 06/06/15

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/31/2006 7:39:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 84 BRACKET

Job Number: 27302

Part Number: D28032

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Jul 06/06/10

20

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAN 06/06/10

20

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST156*

6/12/6

(20)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/13

Job Completion



U 06-06-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27302
Description: Bracket		Part Number:	D2803-2
Inspection Dwg: D2803	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

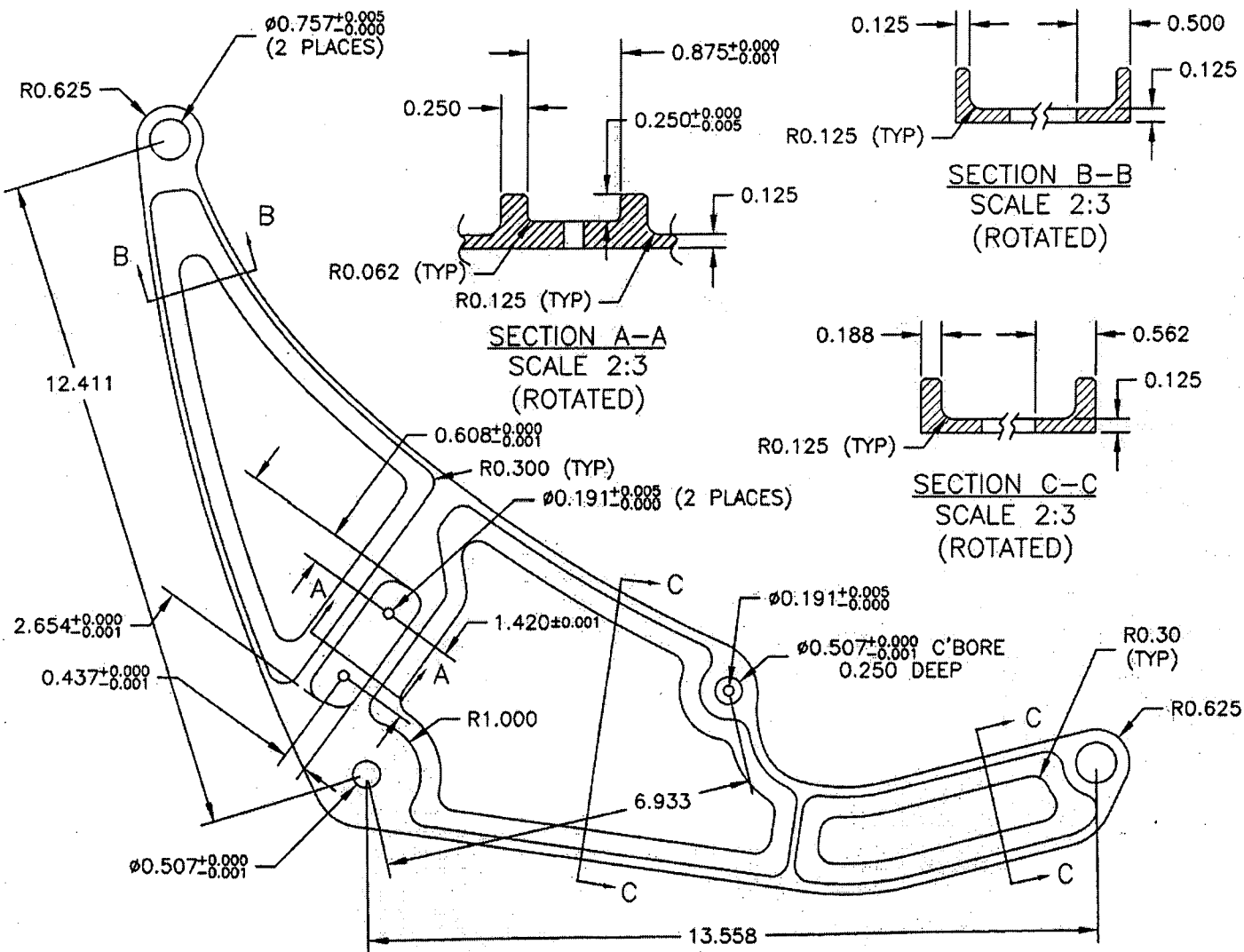
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	Ø,759"				
1.420	+/-0.001	1,420"				
Ø0.191	+0.005/-0.000	Ø,192"				
Ø0.507	+0.000/-0.001	Ø,506"				
Ø0.507 x 0.250	+0.000/-0.001	Ø,506 x,251				
12.411	+/-0.010	~~~~~				
13.558	+/-0.010	~~~~~				
6.933	+/-0.010	6,928"				
0.250	+/-0.010	,250"				
0.875	+0.000/-0.005	,875"				
0.250	+0.000/-0.005	,250"				
0.125	+/-0.010	,126"				
0.125	+/-0.010	,120"				
0.500	+/-0.010	,504"				
PO 0.125	+/-0.010	,125"				
0.188	+/-0.010	,188"				
0.562	+/-0.010	,565"				
0.125	+/-0.010	,120"				
1.420	+/-0.001					

Measured by: J.F.	Audited by: SA	Prototype Approval:	N/A
Date: 06/06/08	Date: 06.06.08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	SHEET 1 OF 2
				D2803	
DATE	04.11.22			TITLE	SCALE
				STA 84 BRACKET	1:3
A	00.11.07			NEW ISSUE	
B	04.11.22			ADD CUTOUTS & -043/-044	

RELEASED05-03-11 *[Signature]***D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27302

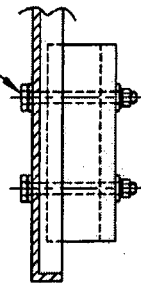
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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3

AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21043-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



SECTION D-D
SCALE 1:3
(ROTATED)

USE D2803-1 FOR D2803-041/-043
USE D2803-2 FOR D2803-042/-044

USE D2805-1 FOR D2803-041
USE D2805-2 FOR D2803-042
USE D2805-3 FOR D2803-043
USE D2805-4 FOR D2803-044
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE
PRIOR TO POWDER COAT

D2803-041/-043 BRACKET ASS'Y (SHOWN)
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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27302

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